

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019692**Date Inspected:** 23-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10:

Repair welding, SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 040582 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path suspending bracket edge plate. Plate identified as BKX51A weld build up 50mm. ZPMC QC Identified as Li Peng Fei with critical welding repair report CWR-B-CWR1868. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair.

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 061938 Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path. Plate identified as BK009A2 stringer plate to deck plate fit up. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112.

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### Magnetic Particle Testing:

This QA Inspector observed AB/F Magnetic Particle Testing Inspector, performed MT on OBG Bike path Stringer plate. Joint identified as BK009A3-001-005, 006.

### BAY 11:

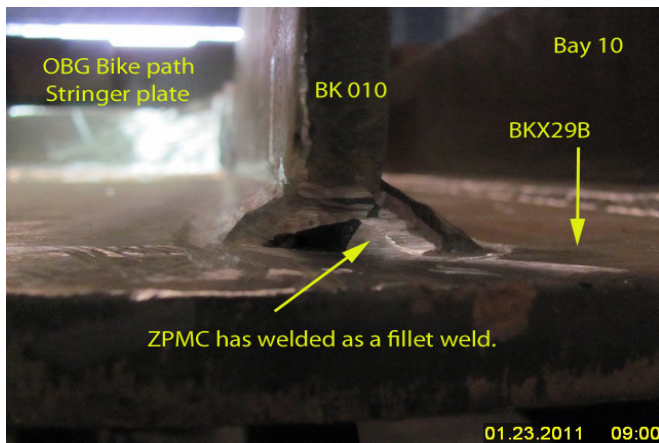
#### Magnetic Particle Testing:

This QA Inspector observed ZPMC Magnetic Particle Testing Inspector, performed MT on OBG Bike path Stringer plate. Joint identified as BK005A1-003-005, 006, 008, 010.

### BAY 10:

During the Quality Assurance (QA) random Visual Inspection of OBG Bike path in Bay # 10. This Quality Assurance Inspector (QA) discovered the following issues: QA Inspector observed the ZPMC personnel have changed the weld joints from PJP to Fillet. According to the approved shop drawing the weld joints between vertical stiffener (BKX55) and the Stringer Plate (BKX29B) shall be a partial joint penetration (PJP). Total twelve (12) weld joints are changed from PJP to fillet by ZPMC personnel. The bike path is identified as BK010A-001. The weld joints was not identified because ZPMC QA did not submitted the Weld Map to CT, OBG Bike path Stringer plate is located in inside Bay#10. For further information, please see the attached pictures.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gaikwad,Shailesh

Quality Assurance Inspector

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**Reviewed By:** Clifford, William

QA Reviewer